



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-725-1-245
Job Sheet 203587



Part No: D212-725-1-245

Job Qty: 2 pcs

Part Name: Cam

6 pcs. B-o



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/19

Job Tracking No:

Due Date: 12/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4163 REV A IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	2 pcs		12/17/19	0.50	0.50	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	2 pcs		12/17/19	0.00	0.00	QC 2 - 1		19-12-12
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-12-12
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S240253



Part: D212-725-1-245

Job No: 203587

Serial No/Batch: S240253

Revision: A

Inspector:

Exp Date:

Instructions: TC STC SH07-28- Issue 2, FAA STC SR0283

					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
112	Conventional Mill - 1 - B4B	2 pcs	12/17/19	0.00 0.67	Conventional Mill - 1 - B4B	19-12-12
					Conventional Mill - 2 - B4B	
114	QC 2	2 pcs	12/17/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	19-12-12
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	2 pcs	12/17/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	

					QC 8 - 58	DEC 19-12-17
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Handfinish - 1-1 Chemical-B4B	2 pcs	12/17/19	0.00 0.20	Handfinish - 1 - 1 - B4B	DEC 16 2019
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140	QC 7	2 pcs	12/17/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	

DAS
82
9-89DAS
81
9-89

				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	DEC 17 2019
				QC 7 - 76	
				QC 7 - 79	
142 Small Fab - 2 - B4B	2 pcs	12/17/19	0.00 0.59	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	DEC 17 2019
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
144 QC 5	2 pcs	12/17/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 17 2019
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	2 pcs	12/17/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
160 QC 21 - SA	2 pcs	12/17/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 53	

DAS
81
9-89DAS
21
9-89

DEC 18 2019

Part Op 100 - Cut blanks 3.250" long. Machine as per folio FA844 and DWG Folio rev: AA Dwg Rev: A

Descriptions: Deburr as per Dwg

110 - Inspect parts off machine FAI/FAIB

112 - Drill & tap as per Dwg.

114 - QC2- Inspect parts off machine FAI/FAIB

120 - Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - Inspect Chemical Conversion Coat

142 - Insert Helicoil as per Dwg

144 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg and stock. Location: _____

160 - Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.625X02.500	6061-T6 Bar .625 X 2.50	.6000 ft (.3 ea)	100-HAAS 4 Axis	S150598
MS21209F1-15	Heli Coil	4 Ea (2 ea)	142-Small Fab - 2 - B4B	FR199682-40

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	M6061T6B0.625X02.500	1	12	0
142-Small Fab - 2 - B4B	MS21209F1-15	4	249	0
Part Specifications				
Specifications could not be found.				

Plex 11/22/19 7:26 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

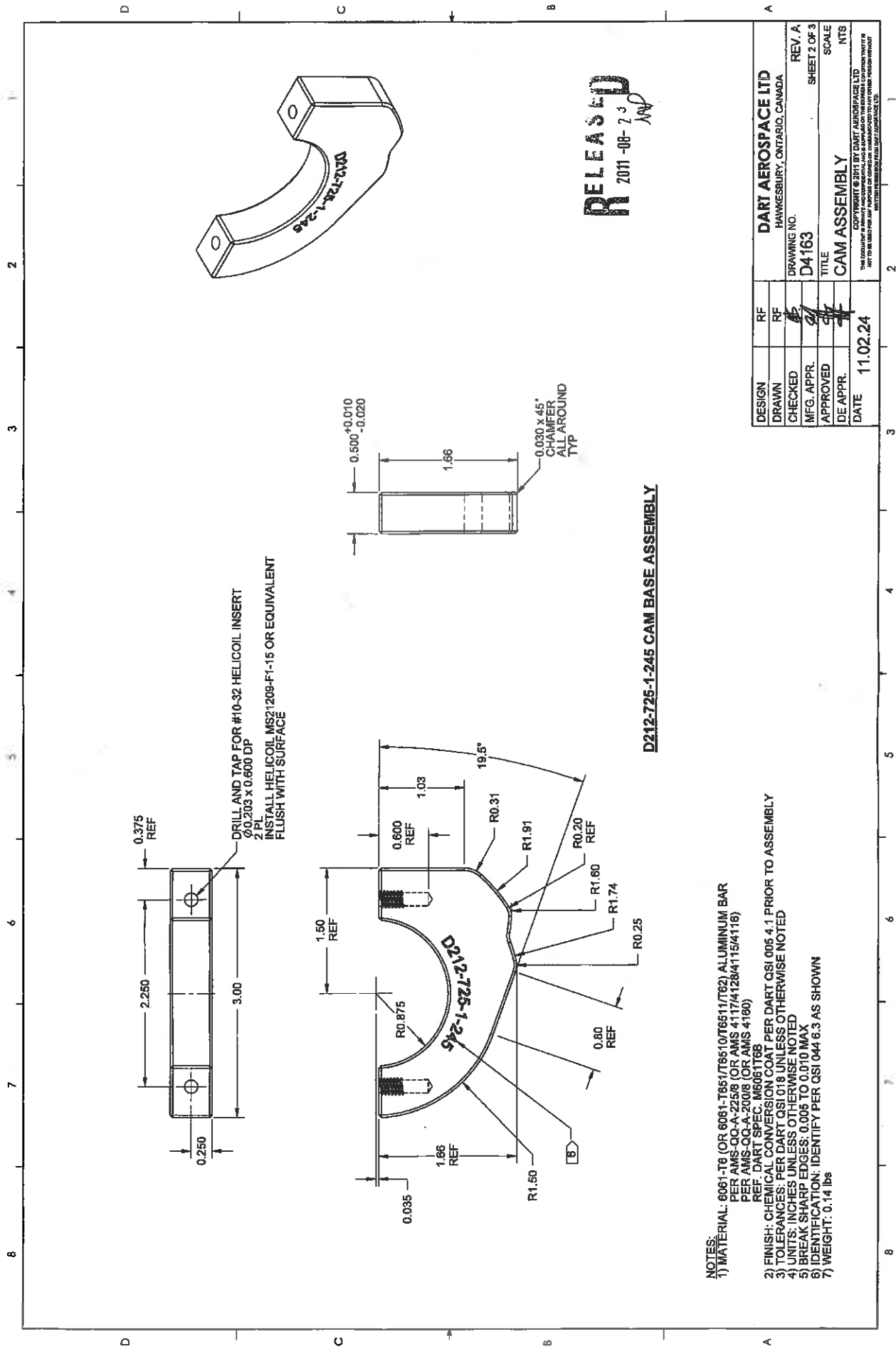
Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		MRB (QSI042)																																																																							
Date : _____		Sequence #: _____		QTY Affected : _____																																																																									
Description Work Order Deviation		Disposition																																																																											
Root Cause		FAULT CATEGORY																																																																											
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Other/Details:		Completed By																																																																											
Lead hand / Supervisor		QC / QA Coordinator																																																																											

Dwg P/N	Description	New Dwg Reference
D212-725-1-199	Tubing	D4253
D212-725-1-201/202	Doubler	D4252
D212-725-1-203	Tubing	D4254
D212-725-1-205	Left Front Panel	D4255
D212-725-1-207	Center Front Panel	D4255
D212-725-1-209	Right Front Panel	D4255
D212-725-1-211	Fairlead Doubler	D4256
D212-725-1-213	Tubing	D4257
D212-725-1-215	Shield Tail Pipe	D4258
D212-725-1-217	Web	D4258
D212-725-1-219	Arc Seal Retainer	D4258
D212-725-1-221	Gusset	D4258
D212-725-1-223	Angle	D4258
D212-725-1-225	Seal Retainer	D4258
D212-725-1-227	Bracket	D4259
D212-725-1-229	Skin	D4263
D212-725-1-231	Stiffener Angle	D4262
D212-725-1-233	Stiffener Angle	D4262
D212-725-1-235	Angle	D4281
D212-725-1-237	Angle	D4281
D212-725-1-239	Drain Tubing	D4286
D212-725-1-241	Drain Tubing	D4284
D212-725-1-243	Drain Tube	D4285
D212-725-1-245	Cam	D4163
D212-725-1-247	Retainer	D4163
D212-725-1-249	Door	D4183
D212-725-1-251	Fwd Duct	D4085
D212-725-1-253	Aft Duct	D4085
D212-725-1-255	Union	D4086
D212-725-1-257	Bracket	D4083
D212-725-1-259	Web	E4452
D212-725-1-261	Packer	E4452
D212-725-1-263	Angle	E4452
D212-725-1-265	Angle	E4452
D212-725-1-267	Packer	E4452
D212-725-1-269	Packer	E4452
D212-725-1-271	Fitting	E4688
D212-725-1-273	Hose Assembly	E4670
D212-725-1-275/276	Receptacle Clip	E4744
D212-725-1-277	Receptacle Clip	E4744
D212-725-1-279/280	Bracket	E4745
D212-725-1-281	Doubler	D4258
D212-725-1-283	Edge Lit Panel	E4750
D212-705-1-285	Caution Light Segment (#1 Hydr Syst)	E4751
D212-725-1-287	Caution Light Segment (Eng icing)	E4751
D212-725-1-289	Caution Light Segment (DC Generator)	E4751
D212-725-1-291	Caution Light Segment (#1 Inverter)	E4751
D212-725-1-293	Caution Light Segment (External Pwr)	E4751
D212-725-1-295	Caution Light Segment (Chip - XMSN)	E4751
D212-725-1-297	Caution Light Segment (-----)	E4751
D212-725-1-299	Caution Light Segment (Chip - 42" GB)	E4751

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. J
MFG. APPR.	N/A	D212-725-1	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	13.10.03	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D212-725-1-245 CAM BASE ASSEMBLY

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/7651/762) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
REF: DART SPEC: M6061T65
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO ASSEMBLY
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 AS SHOWN
 - 7) WEIGHT: 0.14 lbs

DESIGN	RF	RF	DART AEROSPACE LTD
DRAWN	RF	RF	HAWKSBURY, ONTARIO, CANADA
CHECKED	RF	RF	DRAWING NO.
MFG. APPR.	RF	RF	D4163
APPROVED	RF	RF	TITLE
DE APPR.	RF	RF	CAM ASSEMBLY
DATE	11.02.24	11.02.24	SCALE
			NTS

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